Date:

Friday, 29/08/2008 11:38:33 AM

User:

Julie Lecocq

#### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number **Estimate Number** 

: 41671 : 10313

P.O. Number

This Issue : 29/08/2008

: NC

: // First Issue

Prsht Rev.

: 41611 **Previous Run** 

Written By

Checked & Approved By

Comment

: Est: E 02.09.18 Re-format; Incorporated D2648-1

Type

Est Rev:F Now on Waterjet 06-08-14

: SMALL /MED FAB

**Additional Product** 

Job Number:



Seq. #:

2.0

Machine Or Operation:

1010/1025 sheet 16GA

M1010S16GA 1.0



0.0788 sf(s)/Unit Total: 3.1500 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: 105766

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648 

Dwg Rev:

B 8-9-11

Prog Rev:

2-Deburr if necessary

3.0

H3 8-9-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8 4.0

SECOND CHECK



Comment: SECOND CHECK

SMALL FAB 1 5.0

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Form: rprocess

exertes

**Drawing Name** 

**Drawing Number** 

KJ/RF

Description:

: WEARPAD

**Part Number** 

: D26483 . D2648 REV D

: N/A **Project Number** 

: D **Drawing Revision** Material

**Due Date** 

: 15/09/2008

Qty:

40 Um:

Each

Page 1

# Dart Aerospace Ltd

W/O:			V	VORK ORDER C	HANGES				· · · · · · · · · · · · · · · · · · ·	
DATE STEP PROCE		CEDURE CI	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:		·						
	R	Resolution:		Disposition: QA: N/C C			Closed: Date:			
NCR:				DER NON-CON					,	
DATE	STEP	Description of NC		Corrective Action			Verifica	tion	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Desc Chief En		Sign & Date	Section		Chief Eng	QC Inspector
		,				,				
			<u>[</u>							
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NOTE: Date & initial all entries

Date: Friday, 29/08/2008 11:38:34 AM User: 🔒 Julie Lecocq **Process Sheet** Drawing Name: WEARPAD Customer: CU-DAR001 Dart Helicopters Services Part Number: D26483 Job Number: 41671 Job Number: Seq. #: **Description: Machine Or Operation:** 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. \$ 8/09/ 2-Identify as D2648-3 7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch M106762 A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary ecrenter VISUAL INSPECTION OF GROUND WELDS 8.0 QC10 Comment: VISUAL INSPECTION OF GROUND WELDS 9.0 INSPECT WORK TO CURRENT STEP QC5 Comment: INSPECT WORK TO CURRENT STEP 10.0 POWDER COATING POWDER COATING M106442 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 10:30 AM START TIME: 32001= OVEN TEMPERATURE: \_ FINISH TIME: 11.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 12.0 PACKAGING RESOURCE # PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock 08-09/17 Location: FP-17

### Dart Aerospace Ltd

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W/O:			WO	RK ORDER CHANG	ES					<del></del>
DATE	STEP	PRO	CEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	1									
Part No	:	PAR #:	Fault Categ	ory:	_ NCI	R: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	R	esolution:	Disposition	:	QA:	N/C CI	osed:		Date: _	
NCR:	777	\	WORK ORDE	R NON-CONFORM	ANCE	(NCF	R) .			
		Description of NC	Description of NC Corrective Action			Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date		cation tion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	4(67)
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648 Rev: D		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

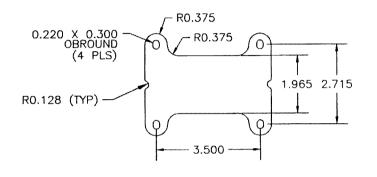
		X	First Article	e	Protot	ype
Ī	Drawing	Tolerance	Actual	Accept	Reject	Metho
	Dimension	Tolerance	Dimension	Accept	Reject	Inspec

Drawing	Tolerance	Actual	Accept	Reject	Method of	Com	ments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	00111	incites
1.965	+/-0.010	1967	*				
2.715	+/-0.010	97720	**				
3.500	+/-0.010		k				
0.220 x 0.300	+/-0.010 x +/-0.010	1	*				,
R0.375	+/-0.010	1375	*				
R0.128	+/-0.010	861.	*				
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Measured by:	KZ	Audited by:	7. '		Prototype A	pproval:	N/A

Measured by: \(\gamma\gamma\)	Audited by:	Prototype Approval:	N/A
Date: 8-9-11	Date: USUALU	Date:	N/A

Rev	Date	Change	Revised by	Approv <i>e</i> d
A	06.10.16	New Issue	KJ/JLM 🚓	

#### D2648-1 FLAT PATTERN



R1.62

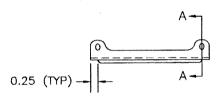
7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

R1.62 — R1.62

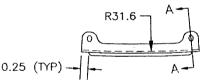
SECTION B-B

D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

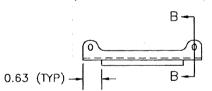
### D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)







BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D		99.11.17	ADDED D2648-7
С		97.06.26	R31.6 WAS R19.6
8		97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
Α		97.03.25	NEW ISSUE
DESIG	<b>H</b>	DRAWN BY	DART DART AEROSPACE USA, INC.
CHEC	KED	APPROVED	DRAWING NO. REV. D
٥	HT .	#	D2648 SHEET 1 OF 1
DATE			TITLE SCALE
laa ·	11.17		WEARPAD 1:2

SHOP COPRETURN TO RETURN TO ENGINEERIN ONTROLLE JECT TO AMEL WITHOUT NO